

Date: Thursday, 10/25/2007 10:05:28 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BASKET HINGE		
Job Number	: 35354					
Estimate Number	: 10588					
P.O. Number	:		Part Number	: D22323		
This Issue	: 10/25/2007	S.O. No. :	Drawing Number	: D2232 REV C		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: / /	Type	Drawing Revision	: C		
Previous Run	: 33290		Material	:		
Written By	:		Due Date	: 10/2/2007 Qty: 50 Um: Each		
Checked & Approved By	:		<i>10/07/07</i>			
Comment	: Est. B 01.06.07 Now laser cut EC Est Rev:C Now on Waterjet 06-10-26 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S11GA	304/316 .125 Sheet <i>4.0095</i>
Comment: Qty.: 0.0729 sf(s)/Unit Total : 3.6435 sf(s) 304/316 .125 Sheet Batch: <i>104934</i> <i>RB 07-10-30</i>		
2.0	WATER JET	FLOW WATER JET
 <i>(PFO)</i> → <i>SG</i> Comment: FLOW WATER JET 1-Cut as per Dwg D2232 Dwg Rev: <i>C</i> <i>RB 07-10-30</i> Prog Rev: <i>C</i> 2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <i>RB 07-10-30</i>
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
 <i>(counter)</i> <i>6 3/10/31</i> <i>(X54)</i> Comment: SECOND CHECK		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
 <i>(Signature)</i> Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2232-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/11/04
 QA: N/C Closed: _____ Date: _____

NCR: 35354		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/31	# 2.0	one part SCRAP due to have a small groove cut into the part from the water jet R.C. there was still pressure	S Initial 07/10/31	SCRAP and Destroy there are enough parts cut extra to cover the loss of one.	B 07-10-31	E 07/10/31	J Asian	G 07/10/31
		as the water jet as it moves from part location						

NOTE: Date & initial all entries

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Job Number: 35354		Part Number: D22323
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: PAT Dual (X54) 07/11/01 AS CW		
7.0	QC21 	FINAL INSPECTION/W/O RELEASE  07.11.01 AF
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion  U 07.11.01		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

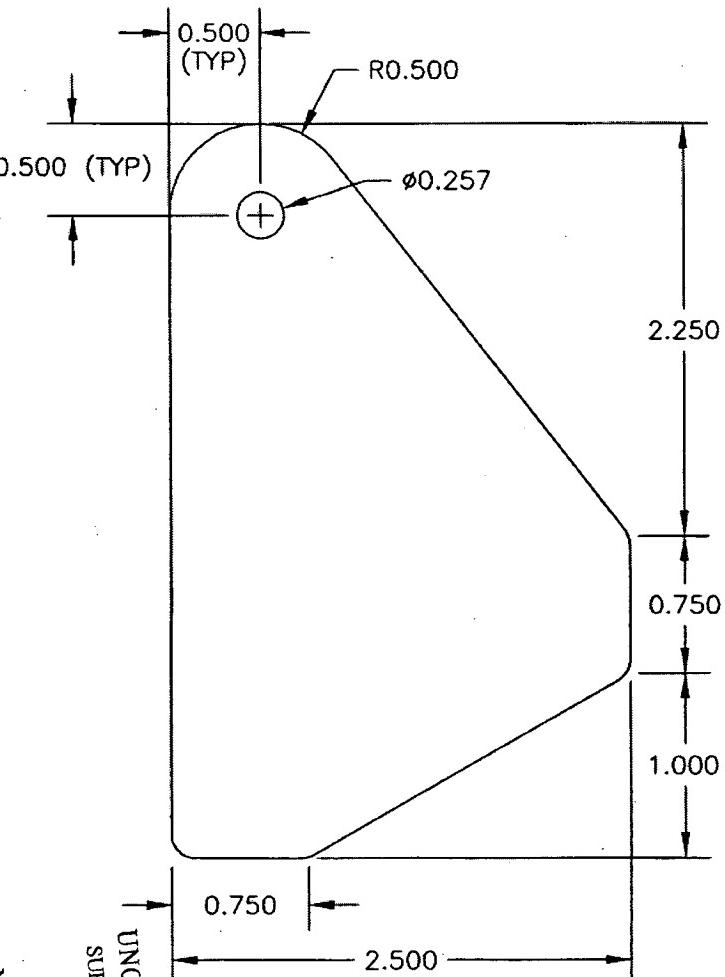
DART AEROSPACE LTD	Work Order:	35354
Description: Basket Hinge	Part Number:	D2232-3
Inspection Dwg: D2232	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

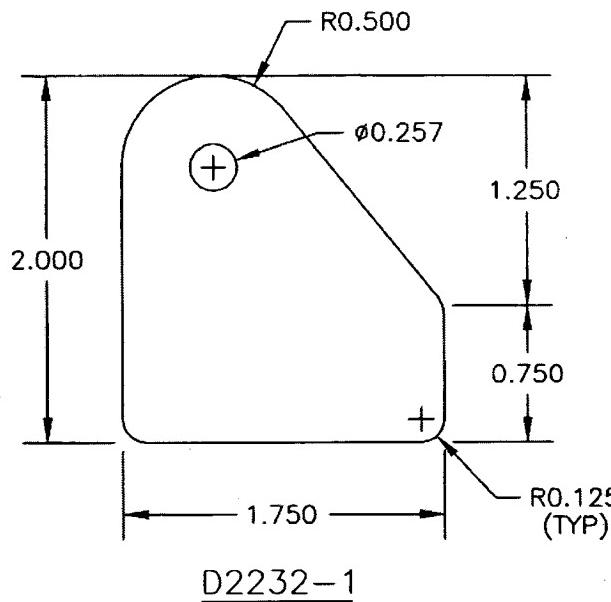
X First Article Prototype

Measured by:	<u>RB</u>	Audited by:	<u>SC</u>	Prototype Approval:	N/A
Date:	<u>07-10-30</u>	Date:	<u>07/10/31</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.11.08	New Issue	KJ/JLM	RE



D2232-3



D2232-1

MATERIAL: AISI 304/316 SS 0.125 THICK

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35354

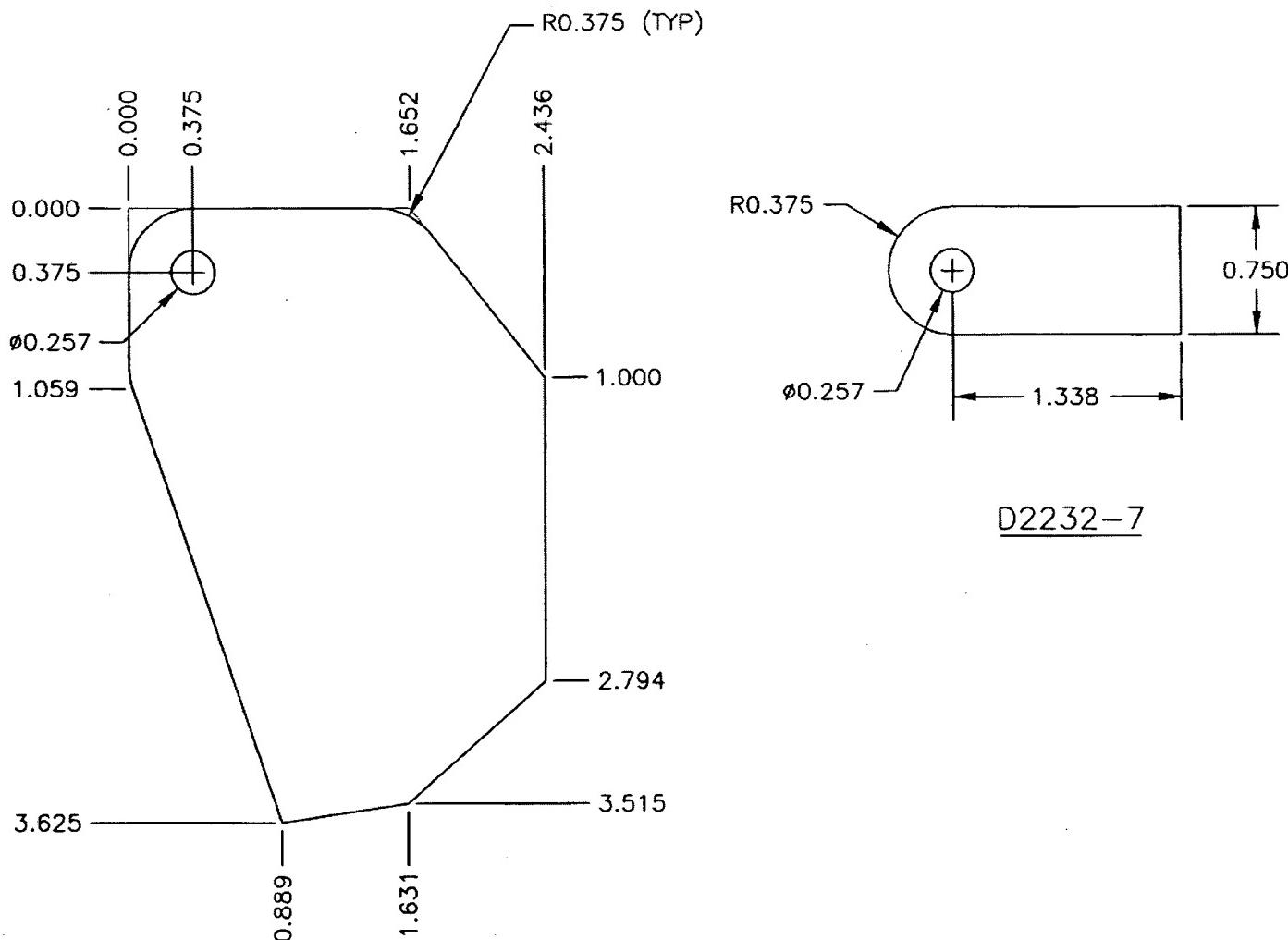
RELEASED
48.05.05
KE

ISSUED
5/9/05
C/C

DESIGN		DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED		DRAWING NO.	REV. C
<i>WJ</i>	<i>JF</i>		D2232	SHEET 1 OF 2
DATE			TITLE	SCALE
98.04.28			BASKET HINGE	1:1
A	94.05.12		NEW ISSUE	
B	96.01.02		ADDED -5 AND -7	
C	98.04.28		0.125 THICK WAS 0.063	

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2232
DATE 98.04.28		SHEET 2 OF 2 TITLE BASKET HINGE SCALE 1:1

RELEASED
98.05.05 KE

MATERIAL: AISI 304/316 SS 0.125 THICK

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 2232-5